

(Blue)

SLIT

Dart Aerospace Ltd.

Date: Monday, 25/06/2007 3:06:18 PM
User: Linda Lacelle



Process Sheet



Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG ASSEMBLY
Job Number	: 33138		
Estimate Number	: 11745		
P.O. Number	: N/A	Part Number	: D3394043
This Issue	: 25/06/2007 S.O. No. : N/A	Drawing Number	: D3394 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A
Previous Run	: 33137	Material	: N/A
Written By	: _____	Due Date	: 07/07/2007
Checked & Approved By	: _____	Qty:	32 Jm: Each
Comment	: Est Rev: A New Issue 06-01-06 JLM		



Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
		
Comment: Qty.: 0.0735 f(s)/Unit Total: 2.3520 f(s)		
D2423 Lug Extrusion		
Batch: 30062 C 207/06/25 2.3520		

2.0	BAND SAW	BAND SAW
		
Comment: BAND SAW		
Cut Blank to .850"		

3.0	OUTSIDE SERVICE	OUTSIDE SERVICES
		
Comment: Sub-Contracting OUTSIDE SERVICES		
Send Blanks To: Metec/Mast Precision Machining		
P/O: 4040 C 207/06/25 (32)		
Machine D3394-3 as per Dwg D3394		

4.0	PACKAGING 1	PACKAGING RESOURCE #1
		
Comment: PACKAGING RESOURCE #1		
Receive & Inspect For Transit Damage		
C 7/6/25 (32)		

5.0	QC6	DIMENSIONAL CHECK
		
Comment: DIMENSIONAL CHECK		
En 07/06/29 (32) counted		

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Drawing Name: LUG ASSEMBLY

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Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

x32

28 07-06-79

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINT
DELFLEET BLUE
CLEAR DELFLEET

210C-4105-C207101105
4198 C207107118

Star

8

ISSUE P.O TO ATELIER DEBOSELAGE

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

207-24

PTU

8

See last page

9.0

MS3548993

GROMMET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 64.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS35489-93	Grommet	M103688

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D3394

21 07-07-24

8

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

21 07/07/24

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:

21/7/24 50

Date: Monday, 25/06/2007 3:06:19 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 33138

Part Number: D3394043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

8
12/06/07

Job Completion

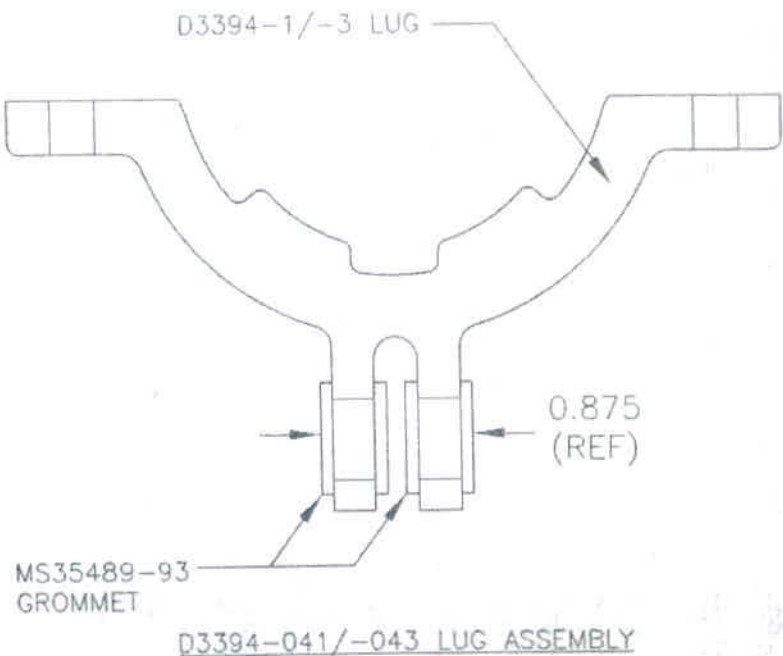


U A-St 24

DART

DESIGN	DRAWN BY	DRAWING NO.	REV. A
04	04	D3394	
CHECKED	APPROVED	TITLE	SHEET 1 OF 3
05.02.14	05.02.14	LUG	SCALE 1:1
A	05.02.14	NEW ISSUE	

40 33138



PARTS LIST FOR D3394-041/-043 LUG ASSEMBLY

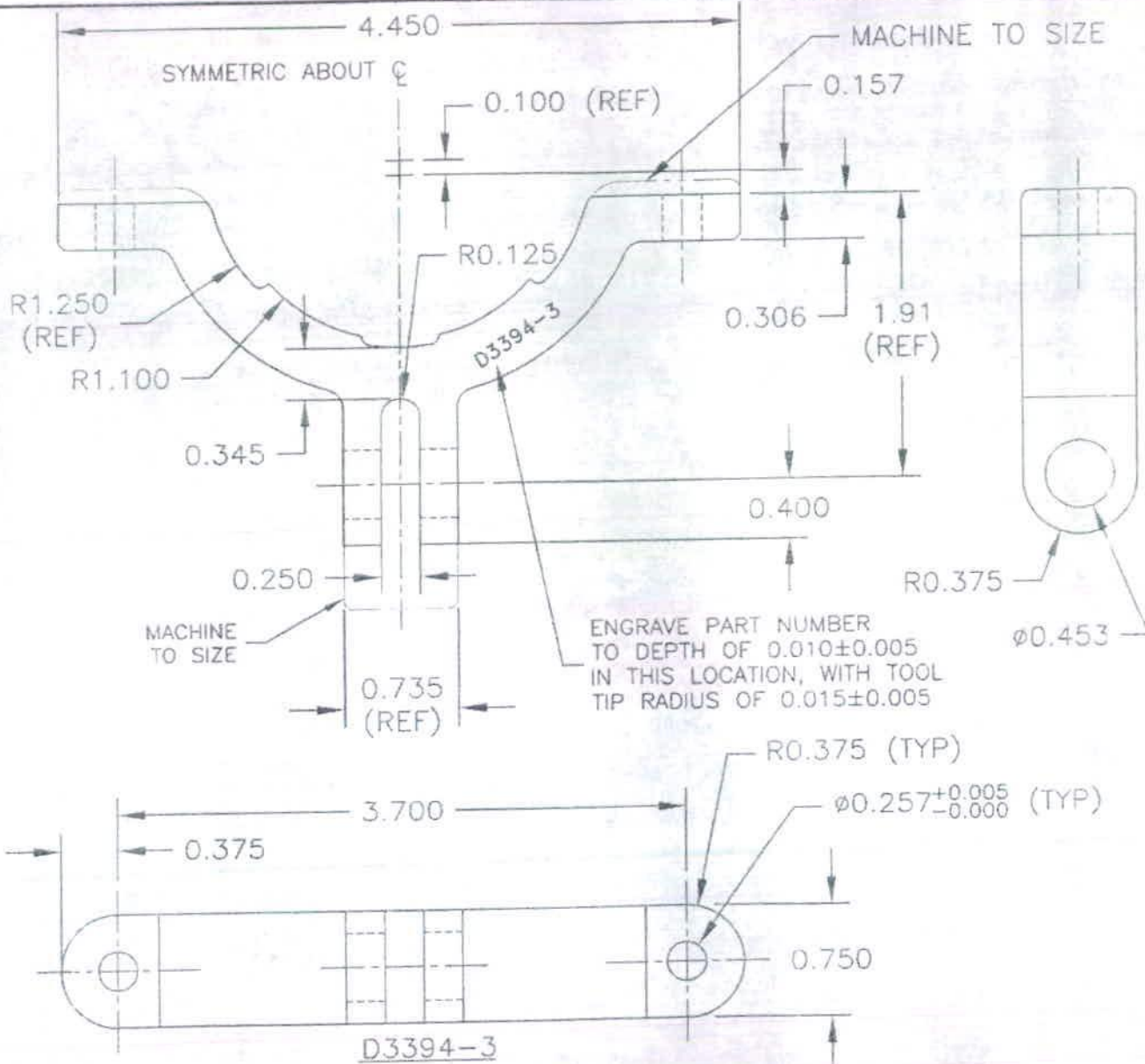
QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3394-041	LUG ASSEMBLY
	X	D3394-043	LUG ASSEMBLY
1		D3394-1	LUG
	1	D3394-3	LUG
2	2	MS35489-93	GROMMET

RELEASED

05.11.14

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3394	REV. A SHEET 3 OF 3
DATE 05.02.14		TITLE LUG	SCALE 1:1

**D3394-3 NOTES**

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05.11.14

[Signature]

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CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

40

D2731-7

Lug B33136

4040

32

D3394-3

Lug B33138

4040

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.






Denise Robinson

Vankleek Hill, June 27, 2007

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070716	7-0	Parts had alot of paint build up on the top / tip of the lug. L.C. tight spot to paint: human error.	 QSI042	same clean parts to remove affected area re-paint blue per QSI045.	P/O 4/98	 070724	 QSI042	 070716

NOTE: Date & initial all entries

